

Work Order ID 71208

Thursday, June 23, 2011 2:45:25 PM



Page 1

Item ID: D6201

Accept



Setup Start



Revision ID:

Stop



Item Name: "T" Extrusion

Start Date: 6/23/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 6/28/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: CZ Date: 11/06/23 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D6201	Rev A

100 PURCHASING 0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O: 19360 (a) Description: T-beam extrusion (b) 4.00" x 4.00" x 0.375" (c) Minimum Ultimate Tensile Strength = 38ksi (d) Minimum Yield Tensile strength = 35ksi (e) Material: 6061-T6/T6511 (QQ-A-200/8) ☐ (f) Material certification required

CZ 11/06/23 20ft

110 Receive & Inspect for Damage & Mat'l Certs 0.00



Packaging

Memo

0.00

Packaging

Ensure material certification is attached

CZ 11/06/28 20ft

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Cust Item ID:

Required Date: 6/28/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

CRH 11/06/29

20AT

Quality Control

Ensure Material certification comply to Dwg D6104

130

Identify as per dwg & Stock Location: MAF

0.00



Packaging

Memo

0.00

CRH 11/06/29

20AT

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/6/30 JF

Quality Control

ME
11-06-29

Picklist Print

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Page 1

Work Order ID: 71208



Parent Item: D6201



Parent Item Name: "T" Extrusion



Start Date: 6/23/2011

Required Date: 6/28/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A: ☐01.05.15 ☐New Issue EC

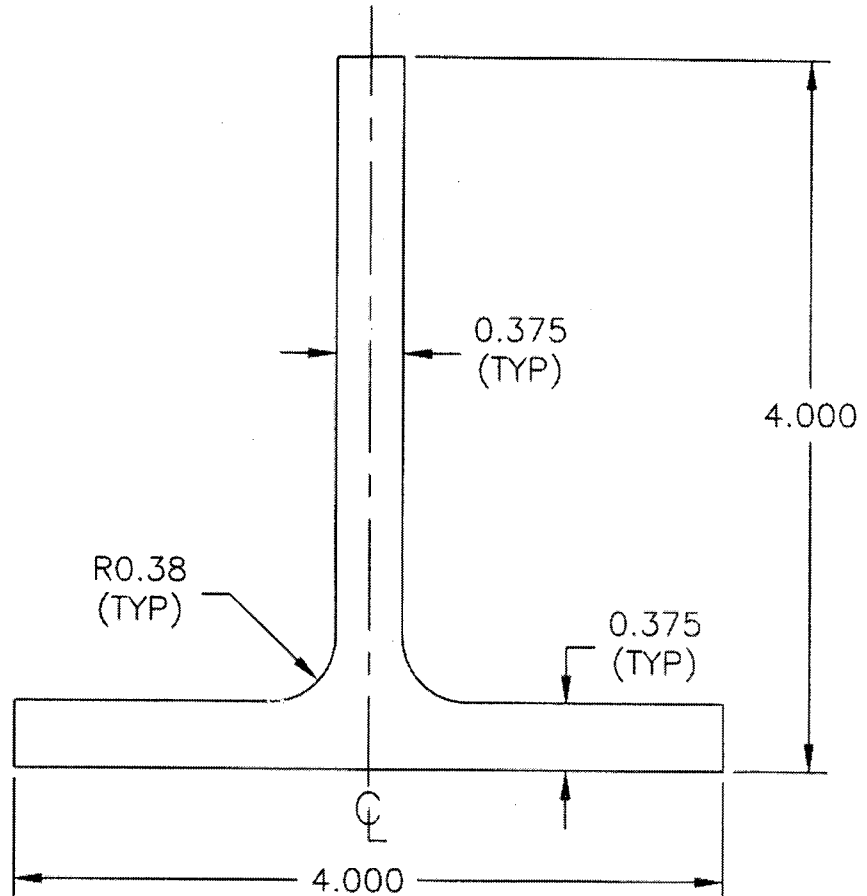
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6201P 		Purchased	No			110	f	0.0000	1	20			
T Extrusion 4X4X3/8											 ME 11-06-29		



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6201	REV. A SHEET 1 OF 1
DATE 01.04.10		TITLE T-BEAM EXTRUSION	SCALE 1:1
A	01.04.10	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *[Signature]*



D6201-XXX T-BEAM EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.
D6201-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM "T"-EXTRUSION ROUND FILLET
4.000" x 4.000" x 0.375"
6061-T6/T6511 (QQ-A-200/8)
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105



PACKING LIST

Page 1 of 1

I045411

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7

SPECIAL INSTRUCTIONS

****STOCK****

Contact: CHANTAL

Ship Terms: PREPAID

MTR:C

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO		
CANADIAN DOLLARS		CHRISTINA ANTONIOU	(613) 632-5200	(613) 632-1053	PO14360		
Sales Order	Terms		Ship Via		Date Ordered	Date Required	Date Shipped
W050100	NET 30 DAYS		NIR:R-557065-1		06/23/11	06/28/11	06/28/11

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
1		PC	ALUMINIUM TEE ATE 6061 T6 3/8" x 4" x 4" x R/L 20' 69 LB / 1 PC MILL TEST + CDEC REQUIS AVEC LIVRAISON PER ASTM B221 SURCHARGE SUR CARBURANT <i>CY 11/06/28</i>	L045637	49903	1 1
Pieces: 1				Approx Weight:		69 LB

Received by: _____ Date: _____ Signature: _____

sapa:

ROCKWELL CERTIFICATION

Customer	Date	Location
MAGNA STAINLESS INC.	11/25/2010	Mississauga
Customer # 61087		Order # 111032
Control # 90304-1		P.O. # 12311
Cust Part # 4"x4"x0.375" T-STR		Die # AS 7520
Alloy & Temper 6061 T6		Cast # 49903

Test results

	Rc E
Min. Req.	88
Actual	93

Typical Chemistry 6061

Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti
0.4-0.8	0.7mx	0.15-0.4	0.15mx	0.8-1.20	0.04-0.35	0.05mx	0.25mx	0.15mx

Tensile testing is performed according to ASTM B557.84 requirements
Mechanical test results conform to specifications for ASTM B 221/SB221, ASTM B 308/ B 308M
except for Sec. 8.2 (Number of Specimens) which is determined by customer requirement
The aluminum extrusions tested meet the chemical composition requirements of the alloy specified.

Tested By: Tom Chia Date: 11/25/2010

Sapa Extrusion
5675 Kennedy Rd.
Mississauga, ON, L4Z 2H9

Tel: (905) - 890 - 8821
Fax: (905) - 890 - 3670

P12311-49903

C019910

